

15.02.27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 129880

February-23-15 10:28:46 AM

129880

Page 2

Item ID: D2002-015 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Knob
 Start Date: 2/23/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	0		DAS 40 9-89 15/02/27
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00				8			DAS 06 9-89 MAR 02 2015
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MCS 150303

AK5.3.3

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

February-23-15 10:28:46 AM

Page 1

Work Order ID: 129880

129880

Parent Item: D2002-015

D2002-015

Parent Item Name: Knob

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C00.05.18Added inspection level 8EC
IPP Rev:D Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased		No			f	5.0500		1		DAS 37 9-89	15-02-27
MDFI RINR1 2500										**			
DELRIN ROUND BAR 1.25" color: black													
					<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
					MAT039		5.05						
					m128113		5.05						
													1 fl.

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Supplier									
Training									
Transport									
Unapproved									

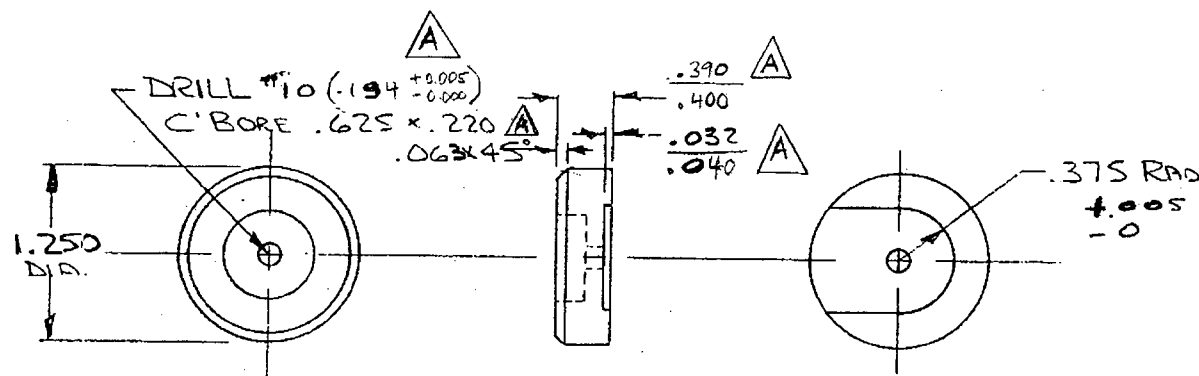
FAULT CATEGORY

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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

19.12.09 DS



DETAIL OF D2002-015

A BLACK UHMW PER D2689

		REVISION DRAWN CHECKED APPROVED DESCRIPTION OF CHANGE		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO. REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES ARE: 3. REMOVE SHARP EDGES 0.18 MAX. 4. THREADS PER IN. — S — 32/32 5. HOLE PER IN. 10/32 1. TOLERANCES — 2. ANGLES .005 ± 0.10 3. RADIUS .005 ± 0.10 4. FINISHES 5. EXCELLENCE 6. SYMMETRY ABOUT ALL VIEWS CENTRE LINES .005		RIVET CODE SMALL RE PER NAS 523 BASIC CODE D-DIMPLE D-DIMPLE OF INSETS D-DIMPLE OF INSETS BASIC CODES B-B-B-B-B-B-B-B B-B-B-B-B-B-B-B		QTY. REQUIRED APPROVAL PART NO. ITEM DESCRIPTION MATERIAL SPEC./VENDOR		CONTRACT NO. DRAWING DESIGN STRESS CHECKED CLIENT		DART AERO ACCESSORIES INC CLIENT TITLE KNOB CODE D 2002 SCALE SHT OF		REV.	
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D2002-015